

Date: Tuesday, 9/25/2007 10:13:36 AM
 User: Kim Johnston

Process Sheet

split up
 07/10/03

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34855 -2
 Estimate Number : 11174
 P.O. Number : N/A
 This Issue : 9/25/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 32285
 Part Number : D3290041
 Drawing Number : D3290 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : EC PER ECN# 799 DC
 Material : N/A
 Due Date : 10/2/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.09.25
 Comment : Est. B.06.05.25 Added Step 11 KJ/JLM
 Est. C 06.05.09 Ecn 798 EC
 Est Rev:D Now on Waterjet 06-06-16 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 ~~M5052H32S040~~ 6061 T6 .040 5052-H32 .040 Sheet



Comment: Qty.: 3.9375 sf(s)/Unit Total : 15.7500 sf(s)

~~5052 H32 .040 Sheet~~

(M5052H32S040)

Batch: M 102723 XB

1B 07-10-1

M 100742 X6

23.625

2.0 WATER JET 31.5000 FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: B 1B 07-10-1

Prog Rev: B

2-Debur if necessary 1B 07-10-1

(14)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counter
 07/10/01 (14)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(14)

BR 07-10-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/03	11	Split u/o	SB	07/09/03	12		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(14X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.f. 07/10/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/10/06

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 26.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch
1 D2126-0780 Locking Seal

Batch

B32619

(2)

13P110

B

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch
1 D3290-1 Window Frame

Batch

34855

24832

W

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch
1 D3290-3 Window

Batch

B29568

L

(PTO)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap


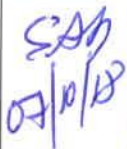
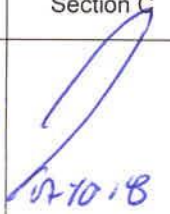


SAN

07/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/16	11	Split W/O	SB	07/10/16	9		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-16	100	1 window D3290-3 B29568 was found with 4 cracked corner. 1 window found with a void in the material, unreparable.	 05/10/16	Scrap: destroy 2 windows.	 07/10/16	 07-10-16	 07-10-16	 07-10-16

NOTE: Date & initial all entries

Date: Tuesday, 9/25/2007 10:13:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

On 07/10/18 (x9) center

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/18 (9)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/19

Job Completion



07-10-19

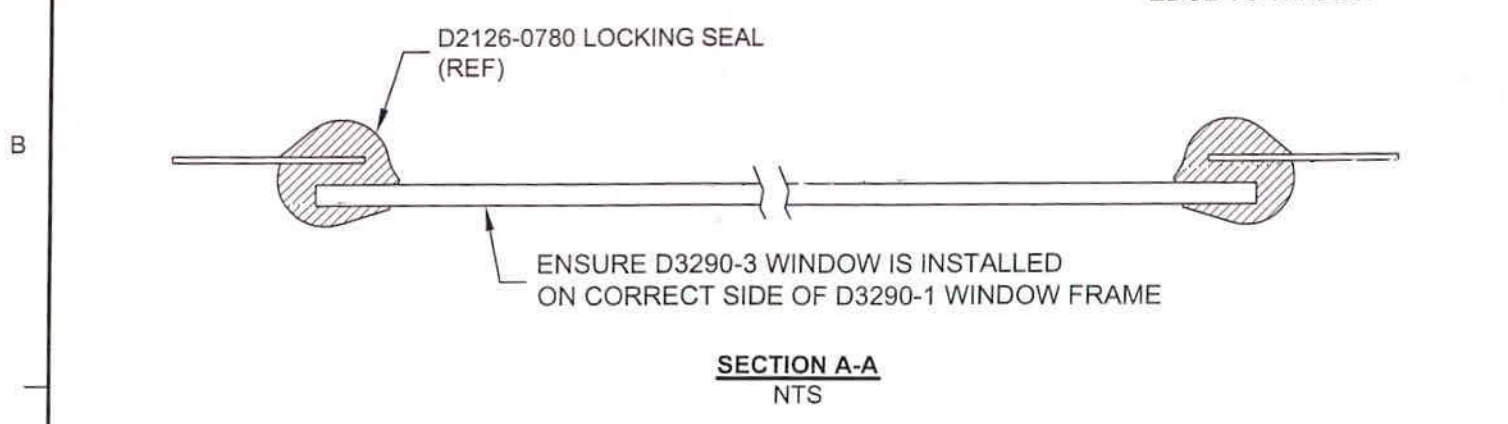
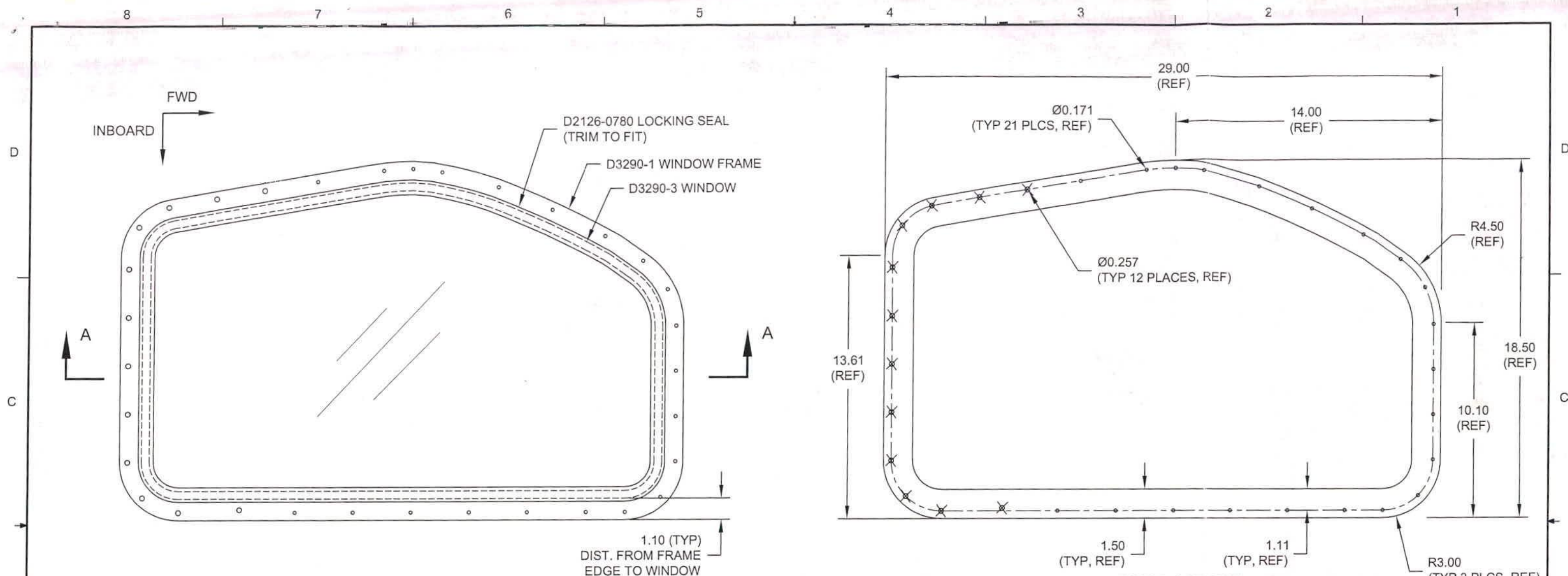
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3290-041 REPLACEMENT WINDOW ASSEMBLY

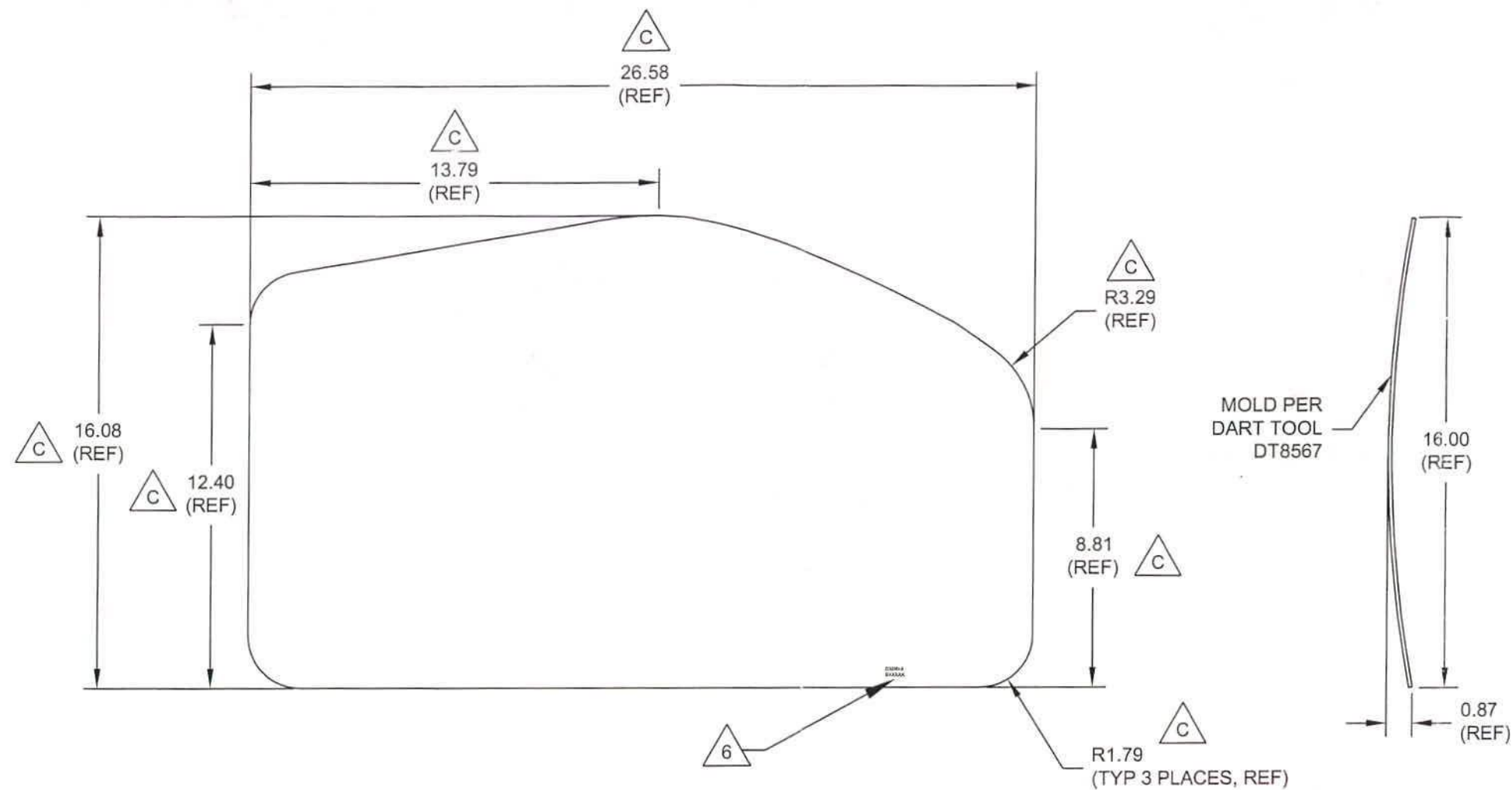
D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

- D3290-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
 - 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
 - 5) WEIGHT: 0.47 LBS

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C	
MFG. APPR.	<i>[Signature]</i>	D3290 SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	REPLACEMENT WINDOW ASSEMBLY 1:5	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SHOP COPY
RETURN TO
ENGINEERING B
RELEASED
07.09.22
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34855



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34855

RELEASED
07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

